

Date: Friday, 10/5/2007 11:02:12 AM
 User: Kim Johnston

Split Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE, OUTBOARD, LH, 206
 Job Number : 35046-2
 Estimate Number : 10818
 P.O. Number :
 This Issue : 10/5/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D26651
 Drawing Number : D2665 REV.D
 Project Number : N/A
 First Issue : 1 / Type : MACHINED PARTS Drawing Revision : D
 Previous Run : 33090 Material :
 Due Date : 10/22/2007 Qty: 2 Um: Each
 Written By :
 Checked & Approved By : 10/07/05
 Comment : Est: C 00.11.01 Removed P/O for Powder Coat - in house
 processEC
 Est Rev:D As per Rev D 07-03-19 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101003 7075-T7351 2X6.25X7.875



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)
 7075-T7351 2X6.25X7.875
 Cut Size 2.0" x 6.25" x 7.88"
 Grain Along Long 7.88 Length Batch no. B34873

2F 08/02/06

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Program batch number.
 1-Inspect part number and batch number are programmed correctly.
 3-Fixturing Inspection last completed on N/A by ---
 4-Machine Step No 1 of Folio and visually inspect as per attached Dimension Sheet
 5-Machine Step No 2 of Folio and visually inspect as per attached Dimension Sheet
 6-Machine Step No 3 of Folio and visually inspect as per attached Dimension Sheet
 7- Deburr

ATO

DTP 08/02/07 2F 08/02/06

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
 Machine Keyway and inspect per attached dimension sheet

DTP 08/02/07 2F 08/02/06

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DTP 08/02/07 2F 08/02/06

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D2665-1 PAR #: N/A Fault Category: Prod / Machine ^{PARTS} NCR: Yes No DQA: D Date: 08/02/08
 QA: N/C Closed: ✓ Date: 08.02.08

NCR: <u>35046</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/02/08	2.0	chamfer tool was set Badly so the chamfer of .050" was .093" R.C operator error	<u>UP</u> 08.02.05 PV QSI 042	SCRAP. DEFECT TOO NOTICEABLE. QTY (X) Replace B# <u>34803</u>	S.F. 08/02/08	<u>✓</u> 08/02/08	<u>UP</u> 08.02.05 PV QSI 042	<u>✓</u> 08/02/08
08/02/07	2.0	Dim "L" 0.110 is under nominal by 0.050. Dim is 0.060 4 PARTS. R.C Human error. hole set too low.		Transferred to -1 split to 08/02/07				

NOTE: Date & initial all entries

Date: Friday, 10/5/2007 11:02:12 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE, OUTBOARD, LH, 206

Job Number: 35046

Part Number: D26651

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SG 08/02/08

(2)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FX 08/02/08 (2)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m106379

FX 08/02/08 (2)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

PC 8/2/8 (2)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 8/2/8 (2)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

ID 08/02/08 (2)

Job Completion



h 08.02.08

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 35046
Description: 206 Saddle, Outboard, Left side	Part Number: D2665-1
Inspection Dwg: D2665 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.100	0.140		.127	.127	.127			
B	0.100	0.140		.136	.136	.136			
C	1.125	1.145		1.135	1.135	1.135			
D	0.615	0.685		.650	.650	.650			
E	0.240	0.260		.259	.259	.259			
F	1.313	1.343		1.328	1.328	1.328			
G	0.210	0.230		.228	.225	.226			
H	0.100	0.180		.141	.140	.140			
I	2.470	2.510		2.493	2.495	2.495			
J	1.565	1.585		1.575	1.575	1.575			
K	0.235	0.240		.250	.251	.251			
L	0.100	0.120		.124	.114	.114			
M	0.990	1.010		1.010	1.010	1.010			
N	0.510	0.515		.510	.510	.510			
O	5.990	6.010		5.999	6.000	6.000			
P	1.245	1.255		1.250	1.250	1.250			
Q	2.495	2.505		2.503	2.500	2.500			
R	0.313	0.318		.313	.313	.313			
S	0.315	0.322		.318	.318	.318			
T	2.495	2.505		2.499	2.498	2.500			
U	1.357	1.367		1.362	1.362	1.362			
V	0.787	0.807		.801	.801	.801			
W	0.540	0.560		.546	.545	.545			
X	1.674	1.684		1.679	1.678	1.678			
Y	0.257	0.262		.258	.258	.258			
Z	0.912	0.932		.927	.927	.927			
AA	0.490	0.510		.503	.503	.503			
AB	0.178	0.198		.188	.188	.188			
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: LF	Audited by:
Date: 08/02/06	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686	KJ/RF	
E	06.07.05	Revised per drawing revision C	KJ/JLM	
F	07.03.21	Revised per drawing revision D	KJ/JLM	

DART AEROSPACE LTD	Work Order: 35046
Description: 206 Saddle, Outboard, Left side	Part Number: D2665-1
Inspection Dwg: D2665 Rev. D	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2665 Rev. D and record below:

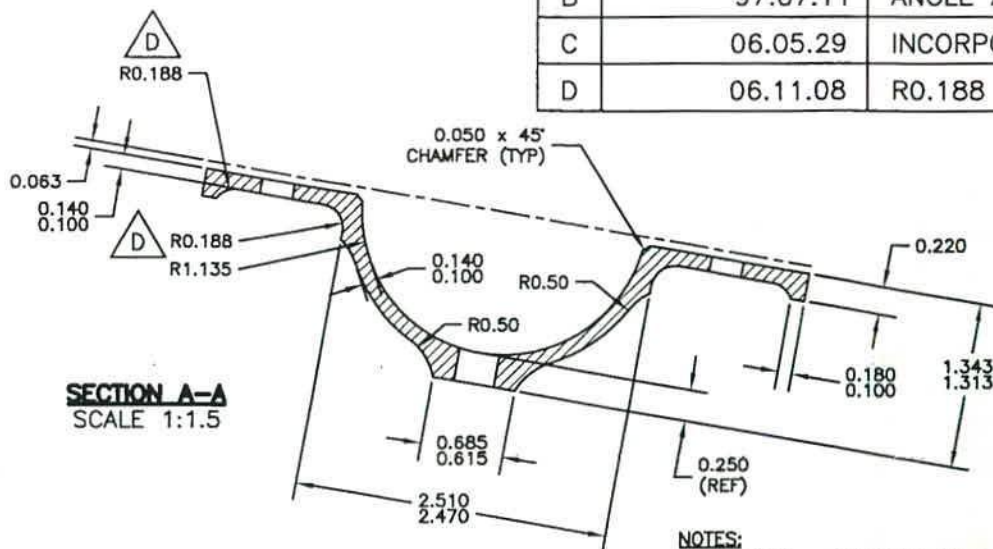
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	50	6	7	8		
A	0.100	0.140		0.128	0.129	0.129	0.130		
B	0.100	0.140		0.1325	0.1325	0.1325	0.1325		
C	1.125	1.145		1.138	1.140	1.140	1.140		
D	0.615	0.685		0.670	0.670	0.670	0.670		
E	0.240	0.260		0.254	0.254	0.254	0.254		
F	1.313	1.343		1.325	1.325	1.325	1.325		
G	0.210	0.230		0.222	0.2185	0.2185	0.2185		
H	0.100	0.180		0.140	0.140	0.140	0.140		
I	2.470	2.510		2.492	2.492	2.494	2.494		
J	1.565	1.585		1.578	1.580	1.580	1.580		
K	0.235	0.240		0.2385	0.238	0.238	0.238		
L	0.100	0.120		0.1165	0.116	0.116	0.116		
M	0.990	1.010		0.106	0.106	0.110	0.110		
N	0.510	0.515		0.510	0.511	0.511	0.511		
O	5.990	6.010		0.6000	0.6000	0.6000	0.6000		
P	1.245	1.255		1.2485	1.2485	1.2485	1.2485		
Q	2.495	2.505		2.499	2.500	2.500	2.500		
R	0.313	0.318		0.314	0.314	0.314	0.314		
S	0.315	0.322		0.3195	0.3195	0.3195	0.3195		
T	2.495	2.505		2.4995	2.500	2.500	2.500		
U	1.357	1.367		1.361		1.361	1.361		
V	0.787	0.807		0.799		0.796	0.796		
W	0.540	0.560		0.548		0.549	0.549		
X	1.674	1.684		1.679		0.679	0.678		
Y	0.257	0.262		0.259		0.259	0.259		
Z	0.912	0.932		0.922		0.924	0.924		
AA	0.490	0.510		0.500		0.502	0.502		
AB	0.178	0.198		0.188		0.188	0.188		
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: DJP	Audited by:
Date: 08/02/07	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
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E	06.07.05	Revised per drawing revision C	KJ/JLM	
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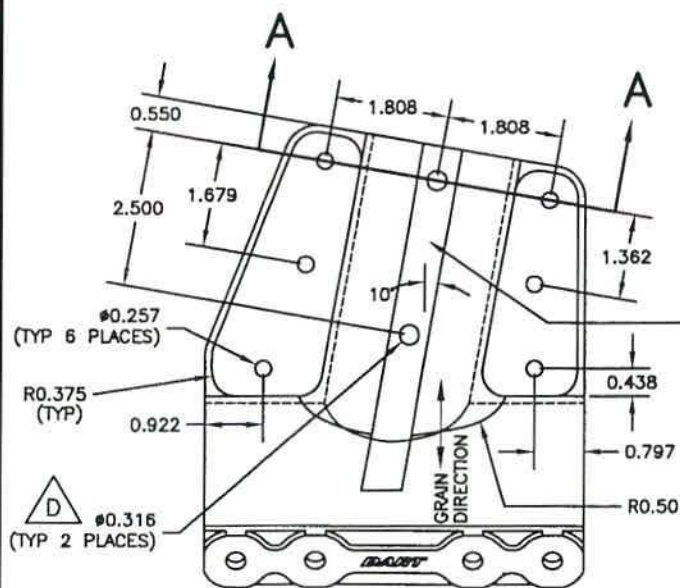
DESIGN	<i>PH</i>	DRAWN BY	<i>CB</i>	DART AEROSPACE USA, INC.	
				PORT HADLOCK, WA	
CHECKED	<i>PH</i>	APPROVED	<i>CB</i>	DRAWING NO.	REV. D
				D2665	SHEET 1 OF 1
DATE	06.11.08			TITLE	SCALE
				SADDLE FWD OUTSIDE HIGH	1:3
A	97.03.25			NEW ISSUE	
B	97.07.11			ANGLE AND NOTES ADDED	
C	06.05.29			INCORPORATE DEO 9122, 9102, 9095	
D	06.11.08			R0.188 WAS R0.30; $\phi 0.316$ WAS $\phi 0.313$	



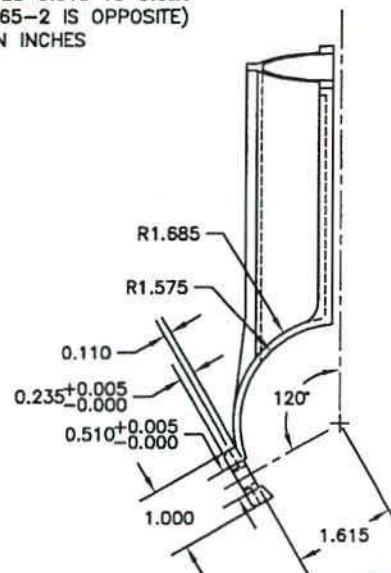
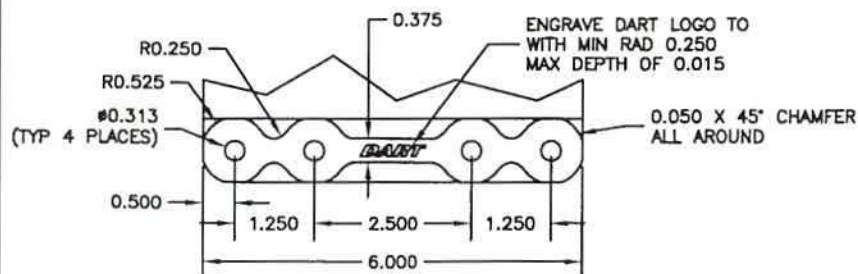
RELEASED
07-02-12 *PH*

NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-003 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2665-1 SHOWN (D2665-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



ENGRAVE PART
NUMBER AND
BATCH NUMBER
TO MAX DEPTH
OF 0.010 WITH
MIN RADIUS
OF 0.010



SHOP COPY
RETURN TO
ENGINEERING

D2665-1 SADDLE FWD OUTSIDE HIGH

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SUBJECT TO
WITHOUT NOTICE
WORK ORDER
NO 35046

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